Work Orde Friday, December														Page
Item ID: Revision 'D:	D3622-9				Accep	ot				s	Setup S			
Item Name:	Ball Stud											Stop		
Start Date:	12/2/2010	Start Qty:	20.00				Cust Ite	m ID:						
Required Date: Reference:	12/15/2010	Req'd Qty:	20.00				Custome	er:						·
Approvals:	Process Pla	an:	M	Date/0-12	-3 Too	ling:		Date:		F		Start		
	QC:			Date:	SPC	C (Y/N):		Date:	-			Stop		
Sequence ID/ Work Center II)	Operation Description				Set Up/ Run Hours	Tool II	D Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr						- 7						
D3622	C												,	
100 Hardinge	•	Hardinge CNC	LATHE S	SMALL	0.0	00				20	_L	5		
Hardinge CNC Lathe	e Small	1-3 FC DV	TURN AS LIO REV VG REV:			2,	2/22			,				
		QC2- Inspect p	arts off m	achine FAI/FAIB	0.0					20	G			
QC Quality Control		M	emo		0.	00	1- 0							
				,	1/	10)12	ノナイ							
120 {		QC8- Inspect p	arts - seco	ond check	0.0	00								
QC Quality Control		M	emo		0.	00 and	olis/22			20		<u>e</u>		

Work Order ID 64340

Friday, December 03, 2010 2:58:21 PM



Page 2

Item ID:

D3622-9

Accept

Setup Start

Stop



Revision IP.

Start Date:

Item Name:

Required Date: 12/15/2010

Ball Stud

12/2/2010

Start Qty: 20.00

Req'd Qty: 20.00



Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC: Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Date: Date: Run Start

Stop

Sequence ID/ Work Center ID

130

Quality Control

Packaging

Operation Description

Identify as per dwg & Stock Location: 070

Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject

Reject Number

Insp. Stamp

Packaging

140

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

Picklist Print

Friday, December 03, 2010 2:58:25 PM

Work Order ID: 64340

Parent Item: D3622-9

Parent Item Jame: Ball Stud

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500		Purchased	No		-	100	f	121.3480	0.108	2.273684	· 70	d/12	120

303 HEX BAR .500

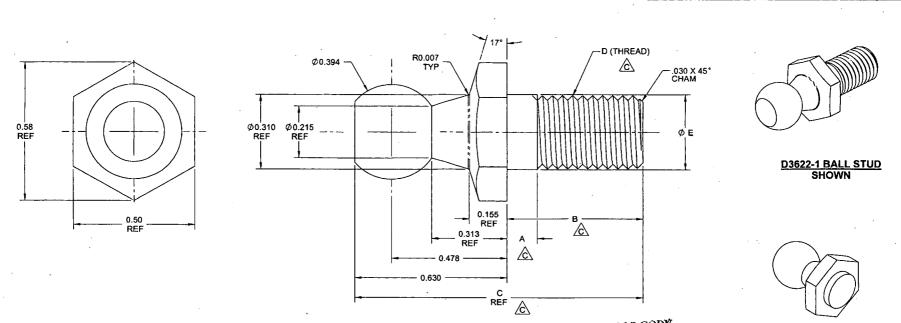
2.2 At

Page 1

DART AEROSPACE LTD	Work Order: 64340
Description: 32 Stud	Part Number: 13623-7
Inspection Dwg: N3622 Rev:	Page 1 of 1

M.O.W. 3336/3363 334 M.C. 3125-3400f3/k N/k Measured by: Audited by: And Prototype Approval: N/A Date: 10/13/22 Date: N/A	Inspection Dwg:	N3622 Rev:	C				Pag	je 1 of 1
X First Article		FIRST A	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
Dimension Tolerance Dimension Accept Reject Inspection Comments		[<u>-</u>			-	•		
Measured by: Date: Date: Date: N/A Date: N/A Rev Date Change Revised by Approves: Revised by	- 1	Tolerance		Accept	Reject			nments
S	.58	= 030	.571	/		Vein	151	- 9
Measured by: Date: Date: Date: Date: N/A	62,	-030	.500					
Measured by: Date: Date: Date: Date: N/A Rev Date Change Revised by Approver	0.310	- 010	01310					1-1
Measured by: Date: Date: Date: Date: N/A Rev Date Change Revised by Approver	0.215	±, 010	0,215	/		0010	1	
1.160	6.394	= 010	0.394					
1.160	.630	2010	.633		<u> </u>			
1.160	1.49	-030	1,492					
Measured by: Date: 1012/22 Prototype Approval: N/A Rev Date Change Revised by Approved.	.090	± 010	.090			/_		
M.O.W3336/.3363 334 77. C 3125-2400f 3 N/A Measured by: Date: 1012/22 Prototype Approval: N/A Date: 1012/22 Prototype Approval: N/A Rev Date Change Revised by Approved	1.160	<u>+</u> . 010	1,160					\
Measured by: Date: 10/12/22 Rev Date Change Audited by: Approved Revised by Approved	3053 . 3125	ALU	309			Mic		
Measured by: Date: 10/12/22 Rev Date Change Audited by: Approved Revised by Approved								
Measured by: Date: 1012/21 Audited by: Approval: N/A Date: 10/12/22 Rev Date Change Revised by Approved Revised by Approved	M.O.W.	.3536/.3363	.334			171.0		
Rev Date Change Addition by: Date: N/A Revised by Approved	3125-240063)	NA						
Rev Date Change Addition by: Date: N/A Revised by Approved								
Rev Date Change Addition by: Date: N/A Revised by Approved								
Rev Date Change Addition by: Date: N/A Revised by Approved								
Rev Date Change Addition by: Date: N/A Revised by Approved								
Date: 1012/2] Date: 10/12/22 Date: N/A Rev Date Change Revised by Approved	Measured by:	-/-	Audited by:	and		Prototype	Approval:	N/A
Rev Date Change Revised by Approved		0/12/22	Date:	10/12/	22		Date:	N/A
	Rev Date	Change						Approved

l				
Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	



PART DIM DIM		DIM	DIM	WEIGHT	THREAD	Ø	E
NUMBER	Α	В	С	(LBS)	D	MIN	MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053	0.3125
(D3622-9"	0.090	_1.160_	1.79	0.04	0.3125-24UNF-3A	0.3053	-0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053	0.3125
							

D3622-X BALL STUD

SHOP COPY RETURNTO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

D3622-11 BALL STUD SHOWN

Taurer	7	
SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
ADD -3 (SHEET 2)	HS	09.09.18
NEW ISSUE	MB	07.04.13
DESCRIPTION	BY	DATE
	ADD -3 (SHEET 2) NEW ISSUE	SHEET 2 DELETED JPH ADD -3 (SHEET 2) HS NEW ISSUE MB

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. C D3622 MFG. APPR SHEET 1 OF 1 APPROVED TITLE SCALE **BALL STUD** DE APPR. NTS

DATE 10.07.20

COPYRIGHT © 2009 BY DART AEROSPACE LTD
THE DOCUMENT IS PRIVATE AND CONFEDENTIAL AND IS SUPPLIED ON THE EXPRESS CONOTING TO BE USED FOR ANY EXPROSE OF COPPED OR COMMANDICATED TO ANY OTHER PRISS

NOTES: 1) MATERIAL: AISI 303 HEX BAR REF DART SPEC M303H0.500

2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE: NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
7) WEIGHT: SEE D3622-X TABLE

8

2

5

3